

Work Order ID 124520

September-11-14 12:08:15 PM

124520

Page 1

Item ID: D350-689-031

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Armrest/Control Guard

Start Date: 9/02/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 14-09-18

Tooling:

Date:

Run Start

NR1

QC: Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9619	B

100 Document Control 0.00

100

DC Memo 0.00

Doc.Control -USB or Paperwork Photocopy D350-689 bluefile & type labels per PPP D350-689-031 CHG001

ML5 14-09-29

2 2 2 14/09/30

101 Pick Kit 0.00

101

Packaging Memo 0.00

Packaging

14/9/29 2 2 2 DAS 32 9-89

110 QC4- 100% Inspect kits for completeness 0.00

110

QC Memo 0.00

Quality Control

2 2 2 14/09/30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

Work Order ID 124520

September-11-14 12:08:15 PM

124520

Page 2

Item ID: D350-689-031

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Armrest/Control Guard

Stop

NS2

Start Date: 9/02/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-689-013								
	Location: <u>027</u>								
	PPP Rev: _____								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS
06

SEP 30 2014

11.5 14-09-30

[Handwritten signature]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

Picklist Print

September-11-14 12:08:14 PM

Page 1

Work Order ID: 124520

124520

Parent Item: D350-689-031

D350-689-031

Parent Item Name: Armrest/Control Guard

Start Date: 9/02/14

Required Date: 9/10/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 12.07.06 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3021-043		Manufactured	No			101	Each	2.0000	1	2			
2 *D3021-043*									**			DAS 32 9-89	06 9-89
Tube Assembly													

Location

Loc Qty

Loc Code

ST445

2

123847

2

D4666-041

Manufactured No

101

Each

1.0000

1

2

2 *D4666-041*

Armrest Assembly

**

DAS
32
9-89

Location

Loc Qty

Loc Code

ST449

1

123846

1

D4671-1

Manufactured No

101

Each

0.0000

1

2

2 *D4671-1*

Armrest Cushion

**

DAS
32
9-89

AN4-4A

Purchased No

101

Each

477.0000

1

2

2 *AN4-4A*

BOLT

**

DAS
32
9-89

Location

Loc Qty

Loc Code

ST346

477

m120187

2

m125709

29

m129390

446

DAS
32
9-89

M129390

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

Picklist Print

September-11-14 12:08:14 PM

Page 2

Work Order ID: 124520

Parent Item: D350-689-031

Parent Item Name: Armrest/Control Guard

124520

D350-689-031

Start Date: 9/02/14

Required Date: 9/10/14

Start Qty: 2.00

Required Qty: 2.00

AN4-10A

Purchased

No

101

Each

43.0000

[1] 2

DAS
32
9-89

DAS
06
9-89

2 *AN4-10A*
Bolt

(DP)

Location

Loc Qty

Loc Code

CA

18

M129682

18

ST355

25

M127815

25

101

Each

407.0000

[1] 2

DAS
32
9-89

DAS
06
9-89

AN4-17A

Purchased

No

2 *AN4-17A*
Bolt

(DP)

Location

Loc Qty

Loc Code

ST343

407

124858

12

M128813

195

M129909

200

101

Each

531.0000

[1] 2

DAS
32
9-89

DAS
06
9-89

AN970-4

Purchased

No

2 *AN970-4*
Washer

(DP)

Location

Loc Qty

Loc Code

ST329

400

m129521

400

ST508

131

m127815

131

m127815

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

Picklist Print

September-11-14 12:08:14 PM

Page 3

Work Order ID: 124520

Parent Item: D350-689-031

Parent Item Name: Armrest/Control Guard

124520

D350-689-031

Start Date: 9/02/14

Required Date: 9/10/14

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

101

Each

4,341.000

[2]

4

2 *MS21042L4*

Locknut

**

DAS
32
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST007

12

121444

12

ST307

4329

126275

5

m126015

12

m126275

27

m127255

63

m127376

11

m127813

831

m128300

69

m128798

811

m129472

1000

m129934

1500

M129472

DAS
06
9-89

NAS1149F0432P

Purchased

No

101

Each

1,570.000

[4]

8

2 *NAS1149F0432P*

WASHER

**

DAS
32
9-89

14/9/29

Location

Loc Qty

Loc Code

ST275

1570

M126221

45

M127813

3

M128429

766

M128591

6

M128995

750

M128429

September-11-14 12:08:14 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 REV. B

REF TCCA STC: SH02-33

REF FAA STC: SR01620NY

REF EASA STC: EASA.IM.R.S.01453

REF BRAZILIAN STC: 2005S03-09

PURPOSE:

TO PROVIDE CUSTOMERS WHO HAVE PURCHASED D350-689-011/-021 DUAL HIGH BACK SEAT KITS WITH AN OPTIONAL D350-689-031 ARMREST/CONTROL GUARD KIT.

THE D350-689-031 ARMREST/CONTROL GUARD KIT REPLACES THE D350-689-019 CONTROL GUARD KIT, WHICH WAS FOUND TO BE INEFFECTIVE.

THE D350-689-031 ARMREST/CONTROL GUARD KIT ACTS AS BOTH AN ARMREST AND A GUARD, THAT PREVENTS PASSENGERS FROM SLIDING OFF THE INBOARD SIDE OF THE SEAT INTO THE CONTROLS.

WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-689-031 ARMREST/CONTROL GUARD KIT (Seat's Fwd position)	1.4 lb 0.64 kg	-9.0 in -0.23 m	- 12.6 in-lb -0.15 m-kG	60.7 in 1.54 m	85 in-lb 0.99 m-kG
D350-689-031 ARMREST/CONTROL GUARD KIT (Seat's Aft position)	1.4 lb 0.64 kg	-9.0 in -0.23 m	- 12.6 in-lb -0.15 m-kG	64.7 in 1.64 m	91 in-lb 1.05 m-kG

14-09-18
NO. 124520 M.C.S
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
RETURN TO
ENGINEERING
SHIP COPY

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	<i>D. Shepherd</i>
D. SHEPHERD (DE # 02)	
DATE:	12.07.11
CERT. NO.:	SH02-33
ISSUE NO.:	1

B	KIT RENAMED FOR CLARITY	AJS	12.07.11
A	NEW ISSUE	AJS	12.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>q</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9619	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ARMREST/CONTROL GUARD KIT	NTS
DATE	12.07.11	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

PARTS LIST:



QTY -011	QTY -013	QTY -021	QTY -023	QTY -031	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X							D350-689-011	DUAL HIGH BACK SEAT INSTL, LH
1	X						D350-689-013	FLOOR PROVISIONS KIT
		X					D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH (REF DSI 9419)
		1	X				D350-689-023	ENERGY ATTENUATING FLOOR PROVISION KIT (REF DSI 9419)
				X			D350-689-031	ARMREST/CONTROL GUARD KIT
1					X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
		1				X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY (REF DSI 9419)
				1			D3021-043	TUBE ASSEMBLY
				1			D4666-041	ARMREST ASSEMBLY
				1			D4671-1	ARMREST CUSHION
				1			AN4-4A	BOLT
				1			AN4-10A	BOLT
				1			AN4-17A	BOLT
				1			AN970-4	WASHER
				2			MS21042L4	NUT
				4			NAS1149F0432P	WASHER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 12.07.11
CERT. NO.: SH02-33
ISSUE NO.: 1

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	qp	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9619	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARMREST/CONTROL GUARD KIT	NTS
DATE	12.07.11	COPYRIGHT © 2012 BY DART AEROSPACE LTD - THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

PROCEDURE:

- 1) THIS INSTALLATION KIT COMES WITH (1X) D4671-1 ARMREST CUSHION. THIS IS AN UNUPHOLSTERED PIECE OF FOAM TO BE USED TO CUSHION THE SEAT'S OCCUPANT FROM THE ARMREST. IT IS NOT REQUIRED TO BE INSTALLED.

FOR CUSTOMERS WISHING TO INSTALL THE D4671-1 ARMREST CUSHION, IT CAN BE CUT TO THE LENGTH DESIRED BY THE INSTALLER. IT CAN BE UPHOLSTERED WITH FABRIC THAT MEETS THE BURN TEST REQUIREMENTS OF FAR 27.853 (OR FAR 25.853b), PRIOR TO INSTALLATION.

INSTALL THE CUSHION BY SLIPPING IT OVER THE D4666-041 ARMREST ASSEMBLY.

- 2) REMOVE THE D350-689-041/-043 SEAT IN ACCORDANCE WITH ICA-D350-689, SECTION 25.2 / 25.4.
- 3) FOR CUSTOMERS EQUIPPED WITH THE D350-689-019 CONTROL GUARD KIT, REMOVE AND DISCARD THE KIT. PLUG THE HOLE IN THE SEAT BACK STRUCTURE USING THE (1X) AN4-10A BOLT, (2X) NAS1149D0432J WASHERS AND (1X) MS21042L4 NUT PROVIDED IN THE D350-689-031 KIT AS SHOWN IN FIGURE 1.
- 4) REMOVE THE D3021-041 TUBE ASSEMBLY FROM THE SEAT BASE STRUCTURE, BY UNFASTENING THE (6X) MS27039-1-19, (2X) MS27039-1-17 SCREWS, (8X) NAS1149D0332J WASHERS AND (8X) MS21042L3 NUTS AS SHOWN IN FIGURE 2. RETAIN THE HARDWARE IF SERVICEABLE.
- 5) REFERRING TO FIGURE 2: REPLACE THE D3021-041 TUBE ASSEMBLY WITH THE D3021-043 TUBE ASSEMBLY ENSURING THAT THE END WITH THE D4667-041 STUD ASSEMBLY FACES INBOARD. REINSTALL THE (6X) MS27039-1-19, (2X) MS27039-1-17 SCREWS, (8X) NAS1149D0332J WASHERS AND (8X) MS21042L3 NUTS. TORQUE FASTENERS TO 20-25 in-lb (2.3-2.8 Nm).

- 6) REFERRING TO FIGURE 2: INSTALL THE D4666-041 ARMREST ASSEMBLY ONTO THE SEAT BASE USING (1X) AN4-4A BOLT AND (1X) AN970-4 WASHER. INSTALL FINGER TIGHT. DO NOT TORQUE AT THIS TIME.




ROTATE THE D4666-041 ARMREST ASSY UNTIL THE HOLE AT THE AFT END OF THE TUBE ALIGNS WITH THE CENTER LINE OF SEAT BACK TUBULAR STRUCTURE . USING THE HOLE IN THE ARMREST AS A GUIDE DRILL Ø0.257 THRU THE SEAT BACK STRUCTURE.

INSTALL (1X) AN4-17A BOLT WITH (2X) NAS1149F0432P WASHER AND (1X) MS21042L4 NUT.

TORQUE AN4 BOLTS TO 50-70 in-lb (5.6-7.9 Nm).

- 7) REINSTALL THE MODIFIED SEAT IN ACCORDANCE WITH ICA-D350-689 SECTION 25.3/25.5.
- 8) UPDATE THE AIRCRAFT LOG BOOK TO INDICATE INSTALLATION OF THE D350-689-031 KIT AND ADJUST WEIGHT AND BALANCE RECORD FOR THE AIRCRAFT WITH THE WEIGHT AND BALANCE DATA PROVIDED IN THIS DOCUMENT.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED 
BY: <u>D. SHEPHERD (DE # 02)</u>
DATE: <u>12.07.11</u>
CERT. NO.: <u>SH02-33</u>
ISSUE NO.: <u>1</u>

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9619	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARMREST/CONTROL GUARD KIT	NTS
DATE	12.07.11	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

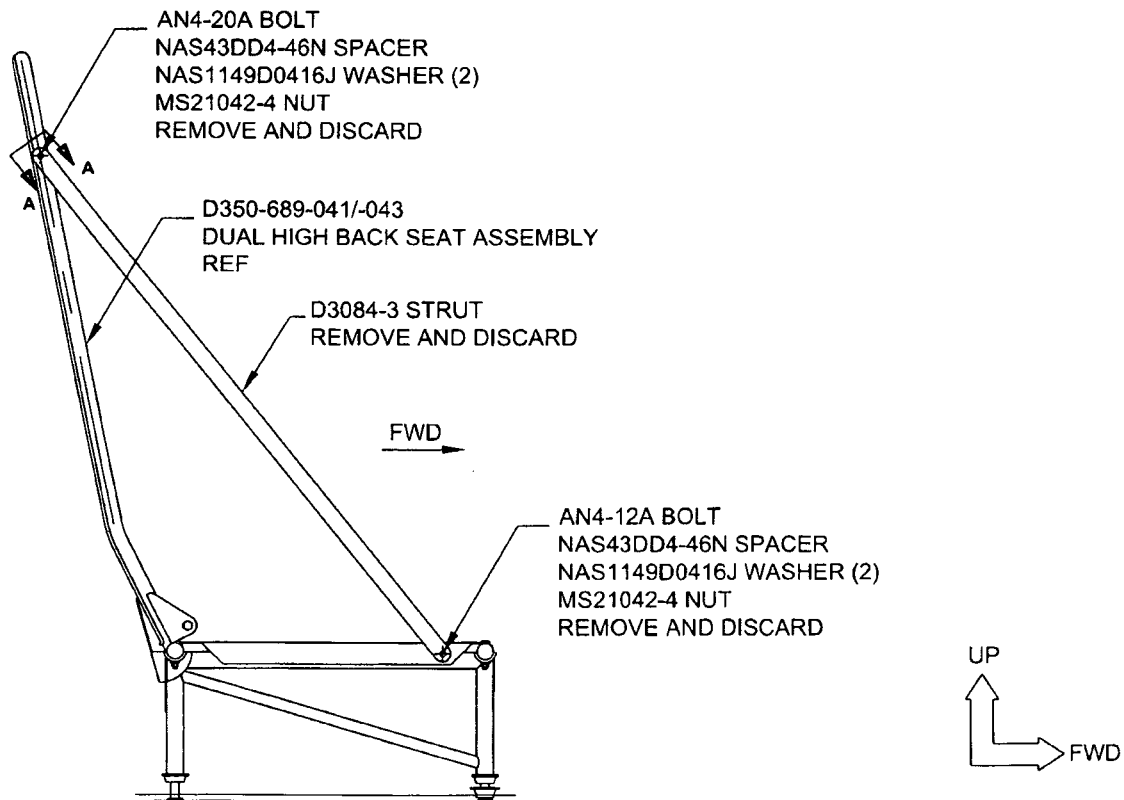
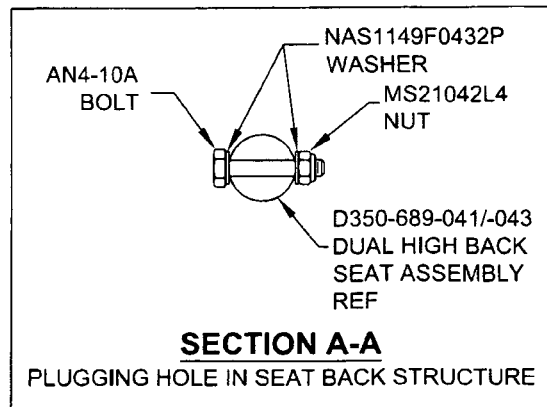


FIGURE 1: Removal of D350-689-019 Control Guard Kit

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.07.11
CERT. NO.: SH02-33
ISSUE NO.: 1

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9619	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ARMREST/CONTROL GUARD KIT	NTS
DATE	12.07.11	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

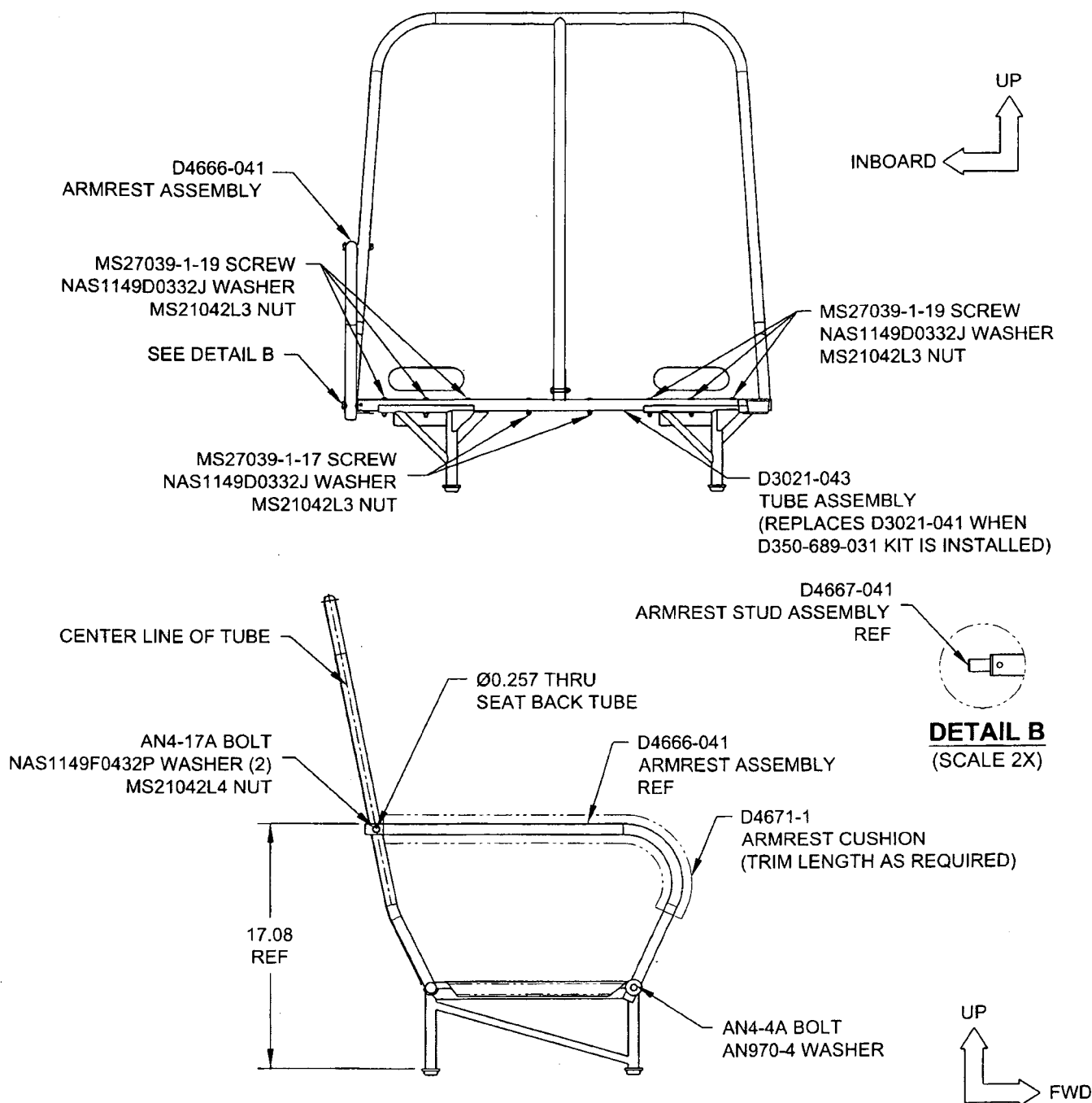


FIGURE 2: D350-689-031 ARMREST/CONTROL GUARD KIT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.07.11
CERT. NO.: SH02-33
ISSUE NO.: 1

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9619	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ARMREST/CONTROL GUARD KIT	NTS
DATE	12.07.11	COPYRIGHT © 2012 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

REFERENCE ONLY

DP 14/04/30

PARTS LIST:

QTY -011	QTY -013	QTY -021	QTY -023	QTY -031	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X							D350-689-011	DUAL HIGH BACK SEAT INSTL, LH
1	X						D350-689-013	FLOOR PROVISIONS KIT
		X					D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH (REF DSI 9419)
		1	X				D350-689-023	ENERGY ATTENUATING FLOOR PROVISION KIT (REF DSI 9419)
				X			D350-689-031	ARMREST/CONTROL GUARD KIT
1					X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
		1				X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY (REF DSI 9419)
				1			D3021-043	TUBE ASSEMBLY
				1			D4666-041	ARMREST ASSEMBLY
				1			D4671-1	ARMREST CUSHION
				1			AN4-4A	BOLT
				1			AN4-10A	BOLT
				1			AN4-17A	BOLT
				1			AN970-4	WASHER
				2			MS21042L4	NUT
				4			NAS1149F0432P	WASHER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.07.11
CERT. NO.: SH02-33
ISSUE NO.: 1

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9619	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ARMREST/CONTROL GUARD KIT	NTS
DATE	12.07.11	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	